

FIG. 1

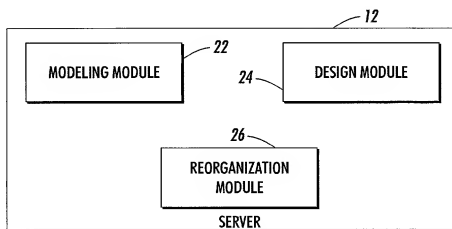


FIG. 2

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### SIMULATIONS FOR LDF

START LIST JOB MODELS QUIT HELP TO LDF HOMEPAGE

**MODELS:**  
 BUSINESS CARDS  
 EMPIRE  
 PRUDENTIAL

**MODEL: EMPIRE**

32 B&W PRINTING → 34 PUNCHING → 36 COIL BINDING → 38 VERIFICATION →

**SPECIFICATION PARAMETERS:**

BOOKS	100
PAGES/BOOK	100
NUMBER OF BATCHES	1
NUMBER OF AVAILABLE OPERATORS	2
PRINT SETUP TIME (HR)	0.02
PRINT SPEED (PAGES/HR)	6000
"NUMBER OF OPERATOR(S) REQUIRED FOR PRINTING (%)	50
PUNCH SETUP TIME (HR)	0.02
PUNCH SPEED (PAGES/HR)	20000
"NUMBER OF OPERATOR(S) REQUIRED FOR PUNCHING (%)	50
COIL SETUP TIME (HR)	0.05

**MODEL: EMPIRE**

**ANALYTICAL TREATMENT:**  
 (FOR UNLIMITING OPERATOR RESOURCE)  
 THE OPTIMAL NUMBER OF BATCHES IS  
 AROUND 8.8 WITH COMPLETION TIME  
 CLOSE TO 2.09 HRS  
 AS LIMITED BY THE BOTTLENECK(S):  
 BW PRINTING  
 COMPUTE PLOT

**ACTUAL SIMULATION:**  
 COMPLETION TIME = 3.31 HRS.

FIG. 3

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☐ Dynamid

☒ Exponential

Mean Time To Failure (Machine 1) 9800 Mean Time To Failure (Machine 2) 9800

Mean Time To Repair (Machine 1) 20 Mean Time To Repair (Machine 2) 20

Mean Production Time (Machine 1) 1.0 Mean Production Time (Machine 2) 1.0

BufferSize (<1000) 100

Compute System Performance

Steady State Production Efficiency Average Buffer Level 0.0

52

54

FIG. 4